

Date: Monday, 11/27/2006 10:05:21 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : ROD
Job Number : 29699	
Estimate Number : 10745	
P.O. Number : <i>N/A</i>	Part Number : D31344
This Issue : 11/27/2006 S.O. No. : <i>N/A</i>	Drawing Number : D3134 REV <i>DE RH</i>
Prsht Rev. : NC	Project Number : N/A 05.11.27
First Issue : <i>N/A</i> Type : MACHINED PARTS	Drawing Revision : <i>DE</i>
Previous Run : 27447	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 12/15/2006 Qty: <i>3</i> Um: Each
Checked & Approved By : <i>[Signature] 06 11 27</i>	
Comment : Est. A 02.11.12 New issue KJ	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TR0250W049	304 SS Seamless Tubing
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Comment: Qty.: 2.3888 f(s)/Unit Total : 9.5550 f(s)

304 SS Seamless Tubing

Cut material to length as per template D3134-3/-4T1

Material: AISI 304/316 Annealed SS tubing 0.250OD x 0.049 wall (M304TR0.250W.049)

Batch: *M100839*

mlo 07/02/14

81" (6'7.50")

2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Open both ends with Ø0.161 (#20) drill and thread both ends as per Dwg D3134

Deburr rod, no sharp edges.

Bend as per Dwg D3134 using template D3134-4T2

mlo 07/02/14

x3

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

07/02/26

(3)

4.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N as per Dwg using a permanent fine point marker, then Stock

Location: *5/27*

07/02/26 (3)

5.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

07/02/27 (3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 9 Date: 07/02/27
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

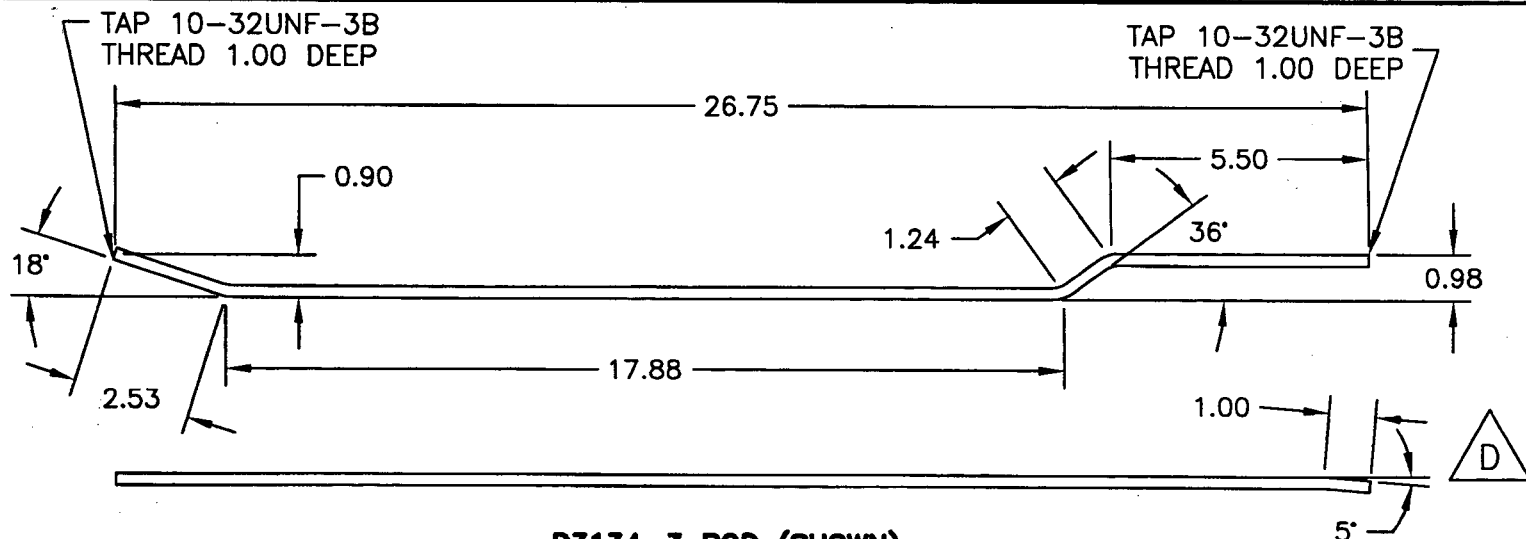
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

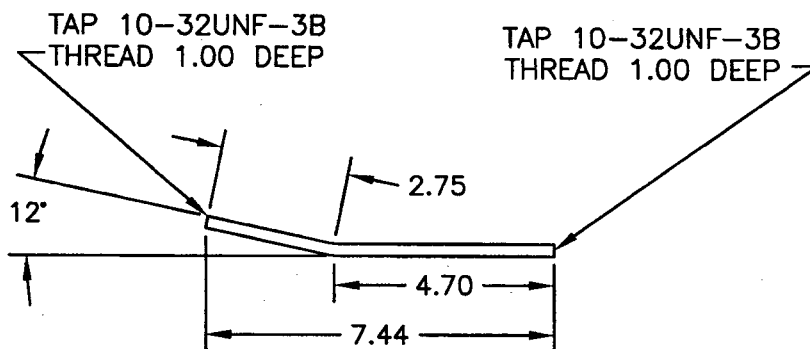
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART



D3134-3 ROD (SHOWN)
(REPLACES PREMIER P/N B30-23000-139)
D3134-4 ROD (OPPOSITE)



D3134-1 ROD
(REPLACES PREMIER P/N B30-23000-137)

DESIGN	PH	DRAWN BY	PH	DART AEROSPACE LTD
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
DATE	06.05.08	TITLE	ROD	REV. E
A	02.04.17	DRAWING NO.	D3134	SHEET 1 OF 2
B	02.09.26	ADD "ANNEALED" SPEC;	REDESIGNED D3134-1	SCALE
C	04.10.18	ADD PART MARKING		NTS
D	05.12.05	CORRECT VIEW		
E	06.05.08	ADD -5, REF DSI 9331		

NOTES

- 1) MATERIAL: AISI 304/316 ANNEALED SS TUBING 0.250 OD x 0.049 WALL (REF DART SPEC. M304TR0.250W.049)
- 2) TOOLING: MAKE D3134-1 PER TOOL DT8656
MAKE D3134-3 PER TOOL DT8657
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 7) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

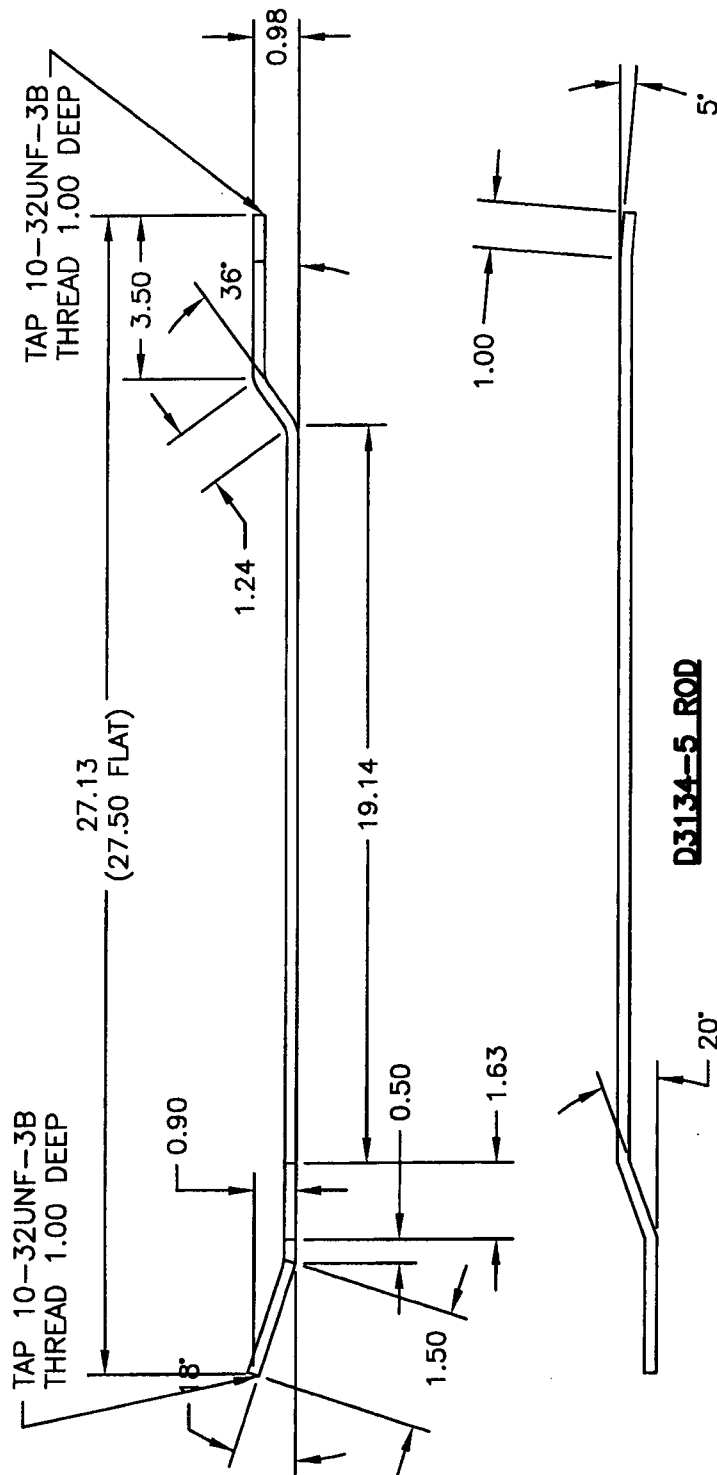
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DART

DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3134	REV. E SHEET 2 OF 2
DATE 06.05.08	TITLE ROD		SCALE NTS



D3134-5 ROD



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RELEASED

06.05.09 *[Signature]*

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